

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021953**Date Inspected:** 16-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

Heat straightening of PCMK, 20TR2-038, under approved Heat Straightening procedure, HSR (B)-461, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhang Ya Xu. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

Bay 8

Heat straightening of PCMK, SA7047-001~011, under approved Heat Straightening procedure, HSR 1 (B)-10201, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Huang Min. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Jian.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

WELDING INSPECTION REPORT

(Continued Page 2 of 5)

Components: Bike Path
PCMK: BK3001-001-001
Welder: 040365
WPS-B-T-2231-ESAB

PCMK: BK16B-001-016
Welder: 040513
Report: B-WR20396
WPS-345-FCAW-1G (1F)-ESAB-repair

PCMK: BK16B-001-017
Welder: 040367
Report: B-WR20396
WPS-345-FCAW-1G (1F)-ESAB-repair

PCMK: BK17B-001-005
Welder: 057266
WPS-B-T-2231-ESAB

PCMK: BK009AB-001-029
Welder: 040302
WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Jian.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: Bike Path
PCMK: BK5A-001-011
Welder: 040581
Report: B-WR20424
WPS-345-SMAW-3G (3F)-repair

PCMK: BK017D-001-002
Welder: 040582
WPS-B-P-2113-TC-U4C

Components: Traveler Rail
PCMK: 31TR2-16
Welder: 057220
WPS-B-P-2212-TC-U4b

WELDING INSPECTION REPORT

(Continued Page 3 of 5)

PCMK: 29TR1-16
Welder: 050038
WPS-B-P-2212-TC-U4b

Components: Tower Lift 6
PCMK: SSD1-FF-SA6-1-131
Welder: 056364
WPS-B-P-2212

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; BK15B-001-, on item number 1 of NWIT tracker document # 08559,

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Mao Bin Bin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: Tower Lift 6
PCMK: ESD1-TL6-2C/D-14A
Welder: 041271
WPS-B-P-2214-TC-U4b

PCMK: ESD1-TL6-2C/D-13
Welder: 046769
WPS-B-P-2314-TC-P4

PCMK: WSD1-TL6-4B/D-67
Welder: 044541
WPS-B-P-2114

Trial Assembly Yard

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Yang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: OBG 12
PCMK: FB3089-001-010

WELDING INSPECTION REPORT

(Continued Page 4 of 5)

Welder: 057333
WPS-B-P-2112-1

PCMK: FB3093-001-012
Welder: 041703
WPS-B-P-2114-1

PCMK: FB3093-001-013
Welder: 202316
WPS-B-P-2112-1

PCMK: SEG3005M-090
Welder: 046709
Report: B-WR 20389
WPS-345-2G (2F)-FCM-repair

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Shin,DJ

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 5 of 5)

Reviewed By: Riley, Ken

QA Reviewer